

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025638**Date Inspected:** 28-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder( OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

NDT:

Segment 13AW

This QA Inspector performed Magnetic Particle Testing (MPT) Verification Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report on this date. The members are identified as Orthotropic Box Girder (OBG) components. The weld designations Verified are as follows.

SEG3013N- 252, 254

AH3001A- 057

EP3024-001-005

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EP3024-001-006

Segment 13AW

This QA Inspector performed a Visual inspection and witnessed Magnetic Particle Testing inspection performed by the ABF QA MT Technicians.

SEG3013D- 302, 305

SEG3013E- 302, 303

SEG3013M- 278, 280

AH3006-001-058

FB3197-001-025, 026, 027, 028

FB3175-001-035

DCP:

Segment 13AE ~ 13BE

This Quality Assurance (QA) Inspector witnessed final tension verification for Cross Beam Side Edge Plate I- Rib. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00717 Dated July 28, 2011

Bolt sizes used were M27 x 95 DHGM 270035 and final torque required was 647 N-m

Bolt sizes used were M27 x 100 DHGM 270039 and final torque required was 673 N-m

Manual Torque wrench was been used with Sr. No. XQ2-600.

Segment 13AE ~ 13BE

This Quality Assurance (QA) Inspector witnessed final tension verification for Cross Beam Side SP I- Rib. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00717 Dated July 28, 2011

Bolt sizes used were M27 x 95 DHGM 270035 and final torque required was 647 N-m

Bolt sizes used were M27 x 100 DHGM 270039 and final torque required was 673 N-m

Manual Torque wrench was been used with Sr. No. XQ2-600.

Segment 13BE ~ 13CE

This Quality Assurance (QA) Inspector witnessed final tension verification for Cross Beam Side SP I- Rib.

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Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00717 Dated July 28, 2011

Bolt sizes used were M24 x 90 DHGM 240029 and final torque required was 600 N-m

Bolt sizes used were M24 x 95 DHGM 240021 and final torque required was 540 N-m

Manual Torque wrench was been used with Sr. No. XQ2-600.

Segment 13BE

This Quality Assurance (QA) Inspector witnessed final tension verification for Cross Beam Side SP I- Rib. Inspected 10% on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00717 Dated July 28, 2011

Bolt sizes used were M27 x 95 DHGM 270035 and final torque required was 647 N-m

Bolt sizes used were M27 x 110 DHGM 270040 and final torque required was 650 N-m

Manual Torque wrench was been used with Sr. No. XQ2-600.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey - 15000026784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhune,Manoj	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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